

Work Order ID 65291

January 11, 2011 9:15:52 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 1/11/11 Start Qty: 1.00

Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

BE 11/01/13

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

B 11/01/19

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M110377/M111385

BE 11/01/19

4- grind fwd cap weld on top surface only

BE 11/01/19

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

B 11/01/20

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 65291

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Item ID: D206-642-541

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Setup Start



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Item Name: Replacement Skidtube

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00

Sublet



QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00

Sublet



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 - 0 1/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Page 4

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							11-1-24
150 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> <u>11/10/10</u> <input type="checkbox"/> Sikaflex expire date: <u>11-7-30</u> <input type="checkbox"/> Start: <u>11/01/24</u> Time: <u>2:00</u> <input type="checkbox"/> Finish: <u>11/01/25</u> Time: <u>7:45AM</u> <input type="checkbox"/> (Adhere for 12 hours)								

3 BE 11/01/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65291

January 11, 2011 9:16:03 AM

Page 5

Item ID: D206-642-541

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 1/11/11 Start Qty: 1.00

Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

DP 11-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 65291

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Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

3.0⁷⁹
4.6⁰

1 ~~0~~ BE 1/27



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R ☐ Aluminum Rod ☒ 11/1385

BE 1/27

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

3 BE 1/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65291

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Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/13

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/16/13

④

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 11/16/13

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

1-0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries




Work Order ID 65291

January 11, 2011 9:16:09 AM

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Item ID:	D206-642-541	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Replacement Skidtube					
Start Date:	1/11/11	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/28/11	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115951.</i> Memo START TIME: <i>9:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:30</i>	0.00 0.00				<i>1</i>		<i>BL 11-02-1</i>	
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>=> M</i>	<i>11/02/02</i>		<i>1</i>	<i>0</i>		
250  HandFinish Hand Finishing	HandFinishing Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. <i>✓ A/RON/AOLPS-3 M109956</i> 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a <i>— A/R Sikaflex-291 M115104</i> Sikaflex expire date: <i>11/01</i>	0.00 0.00	<i>=> M</i>	<i>11/02/02</i>		<i>7</i>	<i>0</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 65291

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Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



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Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

11 02 02 ①

270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ 11/15/11

Sikaflex expire date: ☐ 11/01

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 101A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ 11/15/11

Sikaflex expire date: ☐ 11/01

11 02 02

W/O:		WORK ORDER CHANGES					
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Work Order ID 65291

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Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280



QC

Memo

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8/11/02/02

(70)

290



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

PDP 65291

0.00

P4/10/4 ①

300



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

11/03/17 JF

mf
11-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:15:41 AM

Page 1

Work Order ID: 65291

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-1-190

Manufactured

No

110

Each

52.0000

1

1



Extrusion Round 3" 206

Location

Loc Qty

Loc Code

LG

52

47575

4

59874

48

D3285-1

Manufactured

No

110

Each

122.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

122

52511

74

52647

48

D3282-041

Manufactured

No

150

Each

1.0000

1

1



Float Web (206L/407)

Location

Loc Qty

Loc Code

LG

1

63389

1

B65292



W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

53.0000

12

12



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

53

58545

2

60652

4

61496

2

62889

13

63359

32



BE 1/10/27
B 65317 (12)

D3275-1

Manufactured No

190

Each

28.0000

12

12



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

28

53453

8

62399

1

63546

19



BE 1/10/27
B 65295 (12)

CR3212-4-03 *?

Purchased No

250

Each

1,869.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1869

110153

35

111359

5

112314

2

114436

448

114450

33

114859

1346



BE 1/10/27
X2 110139 X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

January 11, 2011 9:15:42 AM

Work Order ID: 65291

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11



Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No 250 Each 33.0000 1 1
  yl 11/02/02
 Nut Plate



Location Loc Qty Loc Code

ST056 33
33842 33 X1

CCR264SS3-3 Purchased No 250 Each 310.0000 2 2
  yl 11/02/02
 Cherry Rivet

Location Loc Qty Loc Code

ST311 310
 112314 4
 113539 44
113973 262 y2

ALS4-1032-130 Purchased No 250 Each 1,129.000 78 78
  yl 11/02/02
 Insert

Location Loc Qty Loc Code

PKG11 550
 114407 3 M115079 y78
 114723 547
 ST281 444
 116049 444
 ST282 96
110511 10
 115911 86
 ST381 39
 114654 39

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Parent Item Name: Replacement Skidtube

Start Date: 1/11/11



Required Date: 1/28/11

Start Qty: 1.00



Required Qty: 1.00

D3536-15 Manufactured No 270 Each 18.0000 1 1
  xl 11/02/02
 Gasket



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	1	
56055	1	
FP011	16	
<u>63568</u>	16	<u>xl</u>
FP11	1	
59238	1	

D3536-23 Manufactured No 270 Each 11.0000 1 1
  xl 11/02/02
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	11	
<u>63570</u>	11	<u>xl</u>

D3536-35 Manufactured No 270 Each 7.0000 1 1
  xl 11/02/02
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	7	<u>B65573</u>
58683	1	<u>xl</u>
63579	6	

D3536-39 Manufactured No 270 Each 15.0000 1 1
  xl 11/02/02
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	14	
<u>63578</u>	14	<u>xl</u>
FP12	1	
58215	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:15:43 AM

Page 5

Work Order ID: 65291

Parent Item: D206-642-541









Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D3535-15	Manufactured	No	270	Each	11.0000	1	1
							<u>11/02/02</u>
Wearshoe							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		FP18		11			
		63569		11			<u>X1</u>
D3535-35	Manufactured	No	270	Each	8.0000	1	1
							<u>11/02/02</u>
Wearshoe							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		FP018		8		B65575	<u>Y1</u>
		63577		8			
D3535-39	Manufactured	No	270	Each	21.0000	1	1
							<u>11/02/02</u>
Wearshoe							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		FP18		8			<u>Y1</u>
		62945		8			
		FP-18		13			
		64076		13			
D3535-23	Manufactured	No	270	Each	15.0000	1	1
							<u>11/02/02</u>
Wearshoe							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		FP021		15			
		62706		1			
		63571		13			<u>X1</u>

January 11, 2011 9:15:43 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 65291

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D3537-3

 Manufactured No
 Wearpad

270 Each 10.0000 1 1

 HL 1102102


Location Loc Qty Loc Code

FP17 10
 62705 10

D3537-1


 Manufactured No
 Wearpad

270 Each 39.0000 9 9

 HL 1102102

Location Loc Qty Loc Code

FP017 39 B64424
 63545 2
 63997 37


AN960C10L

 NAS1149C0332 Purchased No
 R *
 washer

270 Each 25.0000 80 80

 HL 1102102

Location Loc Qty Loc Code

ST245 25
 107534 25 M116028 Y80

AN960C416

 NAS1149C0463 Purchased No
 R
 washer

270 Each 29.0000 1 1

 HL 1102102

Location Loc Qty Loc Code

ST346 29 M115358 X1
 100993 29

January 11, 2011 9:15:43 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:15:44 AM

Page 7

Work Order ID: 65291

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270 Each

1,309.000 2 2



Phenolic Washer



11/02/02

Location

Loc Qty

Loc Code

ST077

1309

42329

10

52505

299

64177

1000

x2

AN3C4A

Purchased No

270 Each

1,233.000 80 80



BOLT



11/02/02

Location

Loc Qty

Loc Code

ST350

1233

115300

25

115936

208

116075

1000

1115936

Y80

AN4C5A

Purchased No

270 Each

449.0000 1 1



BOLT



11/02/02

Location

Loc Qty

Loc Code

ST346

449

110552

1

112243

448

Y1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:15:44 AM

Page 8

Work Order ID: 65291

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/11/11

Required Date: 1/28/11

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

84.0000

1

1



Aft Cap



Yl 11/02/02

Location

Loc Qty

Loc Code

FP-4

13

57332

13

Yl

FP6

17

52663

3

62678

12

63633

2

Return 2010

54

62678

54

D3413-1

Manufactured No

270

Each

25.0000

1

1



Ring



Yl 11/02/02

Location

Loc Qty

Loc Code

ST420

17

62961

17

Yl

ST473

8

51586

1

53446

7

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07.02.12
DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

652011

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

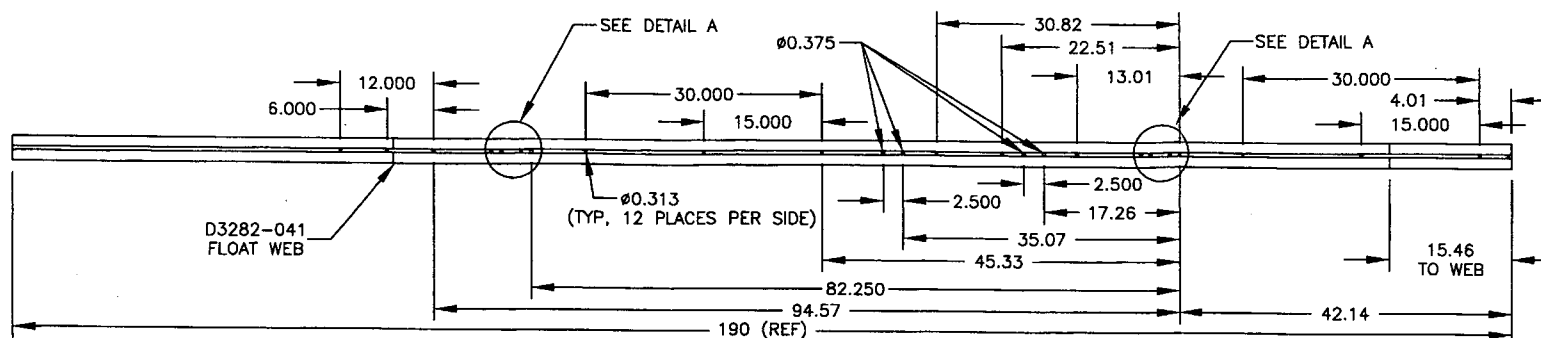
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

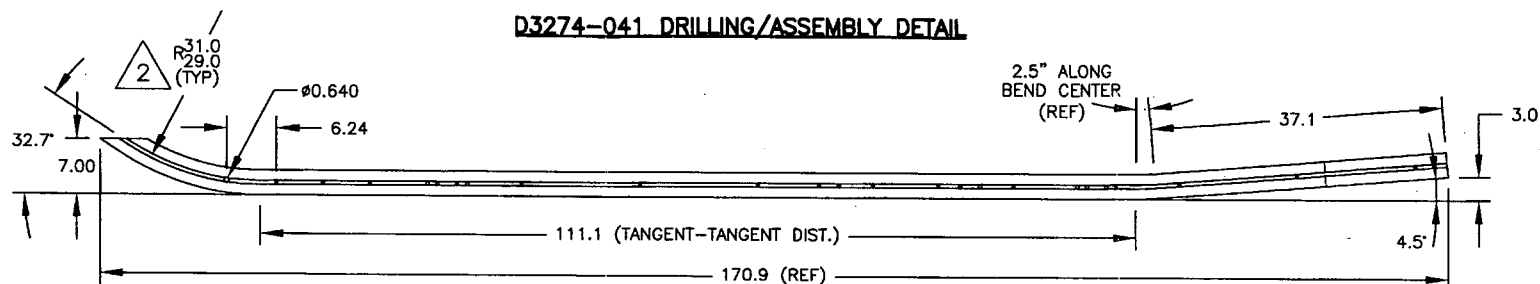
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

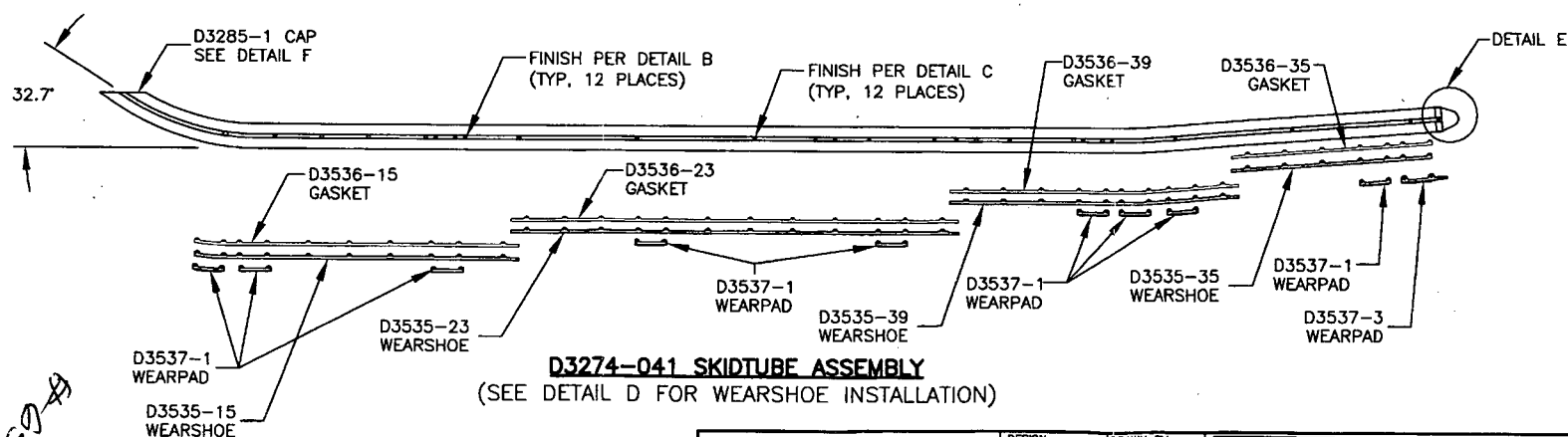
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

16C504

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a float web cross-section. The drawing shows a horizontal profile with various dimensions and callouts. Key features include:

- Dimensions:**
 - Overall width: 190 (REF)
 - Left side dimensions: 3.000 PITCH, 15.000, 1.500 (TYP)
 - Internal dimensions: 30.000, 3.000 PITCH, 1.500 (TYP), 30.82, 22.51, 13.01, 30.000, 4.01, 3.000 PITCH, 1.500 (TYP), 15.46 TO WEB, 42.14
 - Bottom dimensions: 82.250, 91.57, 45.33, 35.07, 17.26, 2.500, 2.500
- Callouts:**
 - SEE DETAIL A (two locations)
 - D3282-041 FLOAT WEB
 - Ø0.375
 - Ø0.313 (TYP, 37 PLACES PER SIDE)

32.7'

D3285-1 CAP
SEE DETAIL F

FINISH PER DETAIL B
(TYP, 12 PLACES)

FINISH PER DETAIL C
(TYP, 37 PLACES)

D3536-15 GASKET

D3536-23 GASKET

D3536-39 GASKET

D3536-35 GASKET

DETAIL E

D3537-1 WEARPAD

D3535-23 WEARSHOE

D3535-39 WEARSHOE

D3537-1 WEARPAD

D3535-35 WEARSHOE

D3537-1 WEARPAD

D3537-3 WEARPAD

D3537-1 WEARPAD

D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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REV. 1

SCALE

1-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

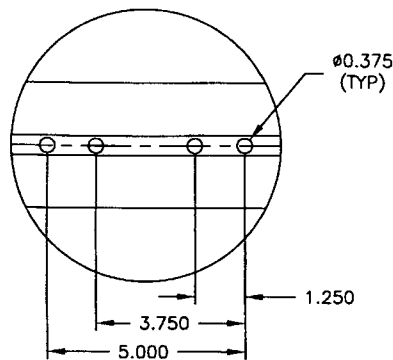
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

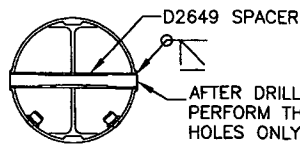
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

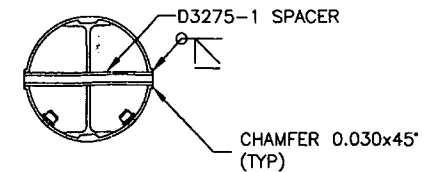


DETAIL B FOR 0.375 HOLES ONLY

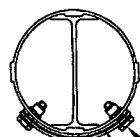


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



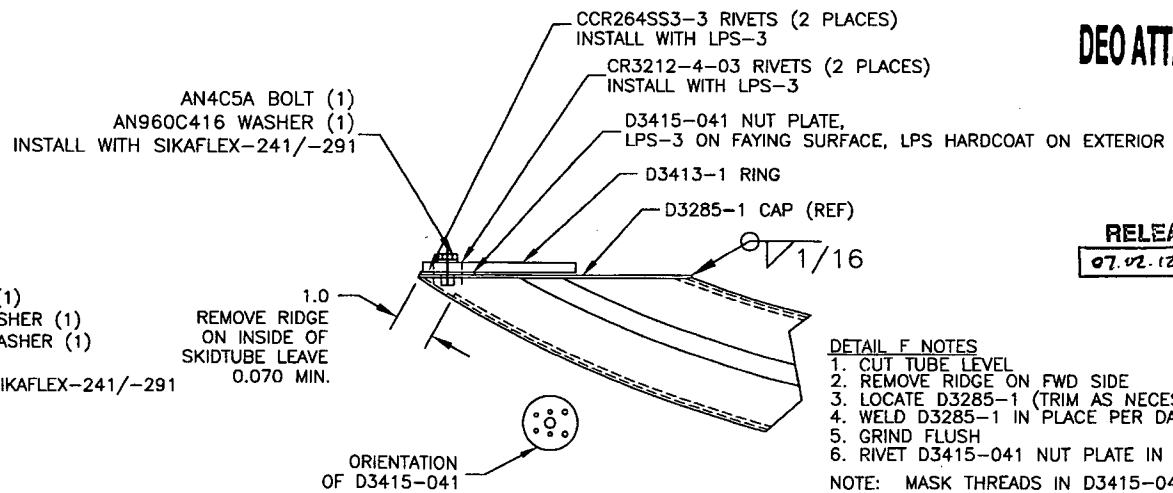
DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

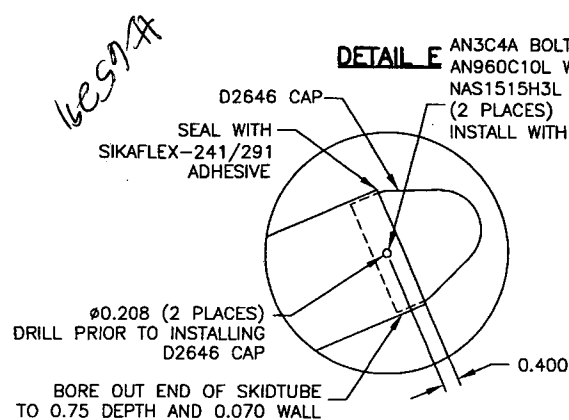
DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

DETAIL E



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DATE 06.12.19		CHECKED #	APPROVED #	TITLE SKIDTUBE ASSEMBLY	SCALE 1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

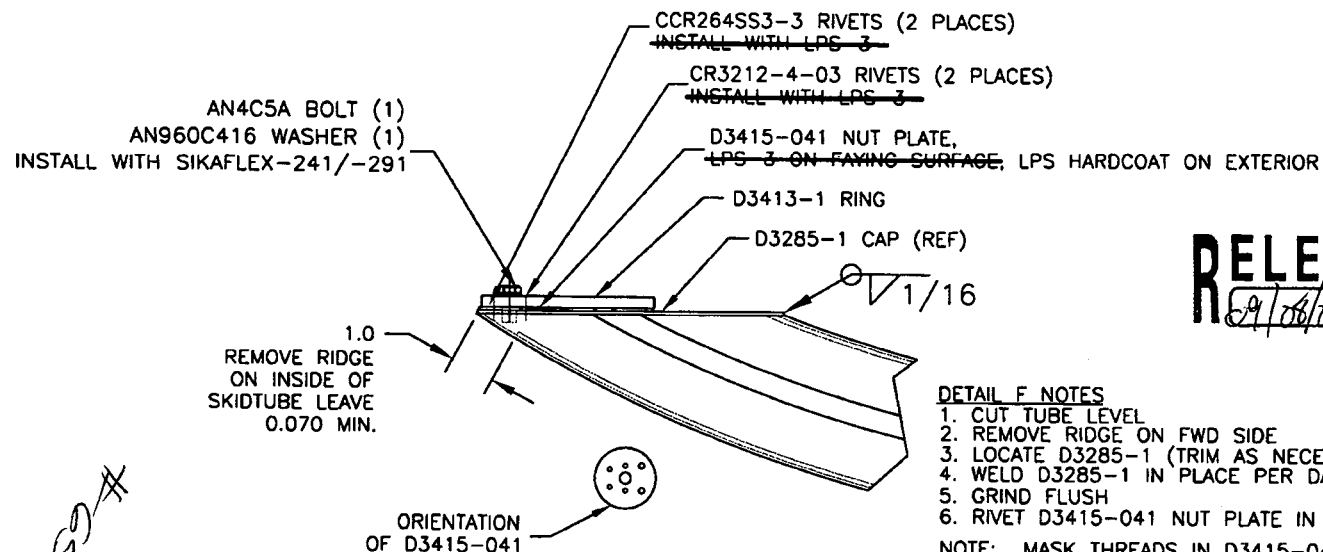
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 242

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 65212
Part number: A 206-642-341
Description: 206 Skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Everett Date of Test Coupon 11-01-13

Welder Barclay Elliott Date of Test Coupon 11-01-13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld